

Date: Friday, 10/5/2007 10:58:51 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : OUTER AFT SADDLE
Job Number : 35035	
Estimate Number : 11080	
P.O. Number : <i>N/A</i>	Part Number : D5955
This Issue : 10/5/2007 S.O. No. : <i>N/A</i>	Drawing Number : D5955 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 32302	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/22/2007 Qty: 8 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: E Re-Format 05-11-29 JLM	
Est Rev: F ecn826 06.12.06 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101013	Saddle billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 D6101-013 (7075-T7351)
 Size 2.50" x 10.10" X 8.25" (Grain along 10.10")
 Batch: *B25357*

*EG 07.11.06**(9)*

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

*EG 07.11.07**(8)*

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

*EG 07.11.07**(8)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*JML 07/11/07**(8)*

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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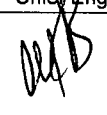
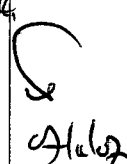
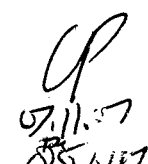
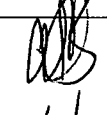
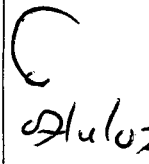

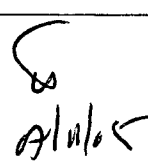

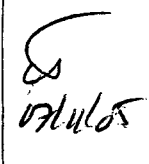


Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

*FL 07/11/07**(8)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 72 Date: 07/11/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/05	# 2.1	one SADDLE has hole Pattern off by 0.017 normal (0.003" over tol.) R.C. operator changed & origin not "y". Hammer error	 07/11/07	test fit on steel with matching SADDLE. SCRAP PART Part doesn't plug	 07/11/07 051042	 07/11/07	 07/11/07	 07/11/07
07/11/05	# 2.1	one SADDLE has a large chamfer on back Section Cured AA.	 07/11/07	Acceptable.	SL 07/11/05	 07/11/05	 07/11/07	 07/11/05

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 35035

Part Number: D5955

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M105914



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

JS

09-11-04

(X8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JS

FL



07/11/08

(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 421

(X8)

AS

07/11/09

✓

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

Dan/09

Job Completion



U Still 09

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35035
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.749	4.750	4.750	4.750		
G	0.315	0.322		.319	.319	.319	.319		
H	1.522	1.532		1.527	1.527	1.526	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.579	4.579	4.580	4.580		
K	0.313	0.318		.319	.319	.319	.319		
L	0.495	0.505		.497	.499	.498	.500		
M	0.490	0.510		.503	.502	.503	.503		
N	1.865	1.885		1.885	1.885	1.885	1.885		
O	7.990	8.010		8.001	8.001	8.001	8.000		
P	2.240	2.260		2.249	2.256	2.258	2.260		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.499	.490	.501	.501		
T	1.625	1.645		1.638	1.636	1.636	1.638		
U	2.000	2.020		2.002	2.004	2.001	2.003		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L / BC
Date:	07/11/04

Audited by:	mk
Date:	07/11/07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	

DART AEROSPACE LTD		Work Order:	35035
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	A ₅	A ₆	A ₇	A ₈		
A	0.438	0.443		.442	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.320	.320	.320	.320		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.504	.504	.505	.505		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.003	8.003	8.003	8.003		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.307	.310	.310	.310		
R	0.760	0.765		.764	.764	.764	.764		
S	0.490	0.510		.505	.505	.508	.508		
T	1.625	1.645		1.637	1.636	1.640	1.646		
U	2.000	2.020		2.003	2.004	2.010	2.010		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

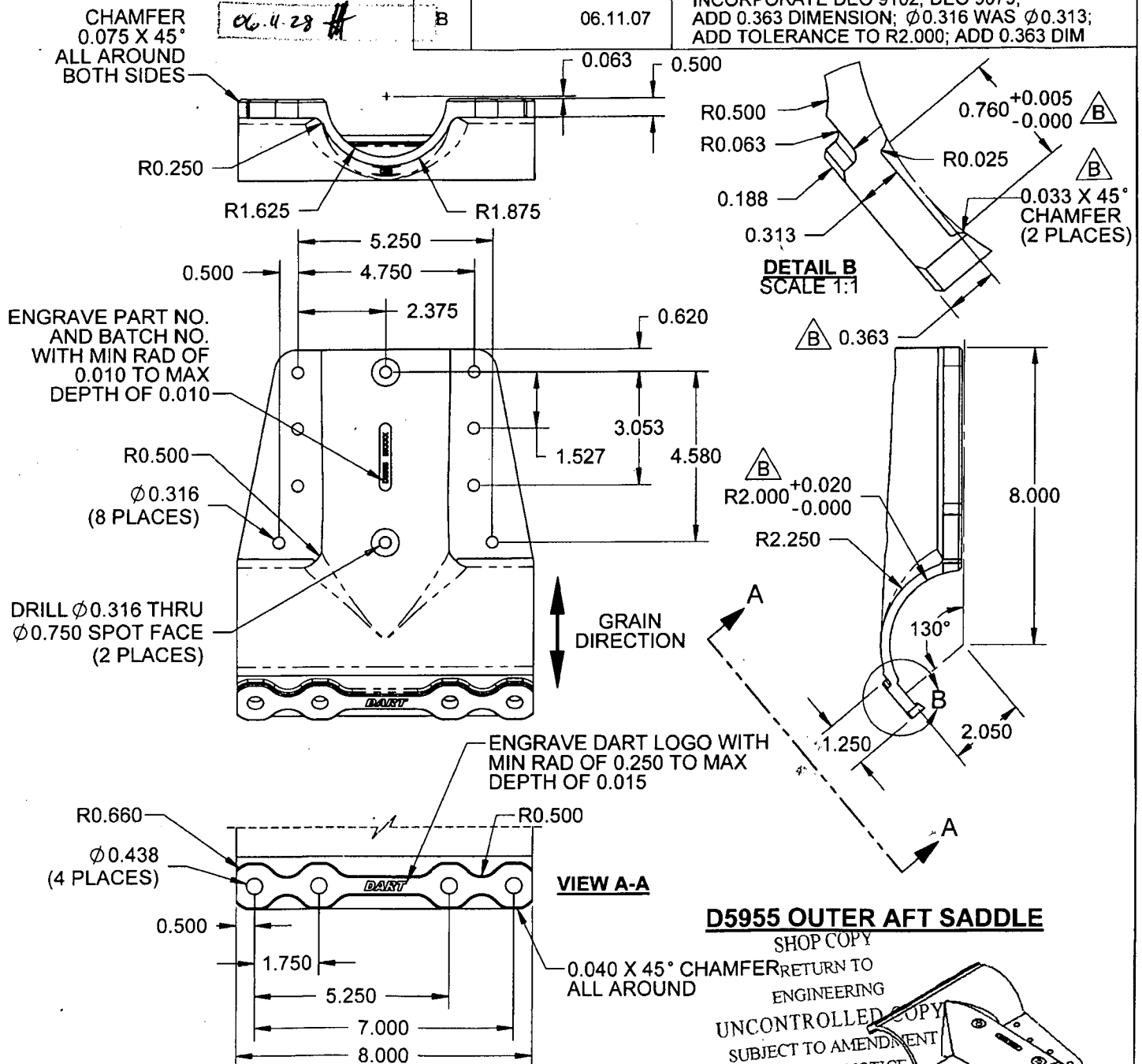
Measured by:	RF
Date:	07.11.06

Audited by:	RF
Date:	07/11/07

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED HA	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE OUTER AFT SADDLE		SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

D5955 OUTER AFT SADDLE

SHOP COPY

RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
35035NO. $\triangle B$ **ISOMETRIC VIEW**

SCALE 1:8

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